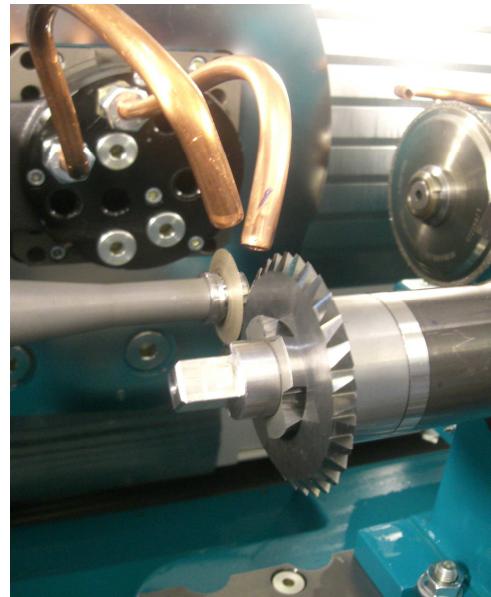


Prism Cutter Ø75 Z32 V30° R.05

A4-110

The V-Shaped Prism cutter with roof radius can be resharpened in several ways. Using a 14EE1 and grinding around the V-Shape of the cutter leads to the best surface finish and a precise small roof radius of 0.05 mm. If the resharpening process has to be automated, a pin-clamping-system is used. In order to compensate eventual eccentricity a probe cycle measuring the center bore is involved.



1. Cycletime for Resharpening

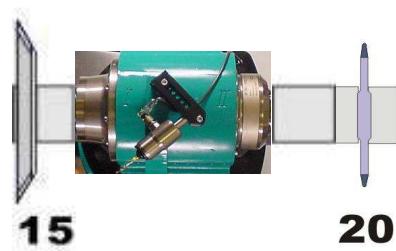
Tool specifications			
Ø75 mm, Z32, thickness 4 mm, Roof Rad. 0.05 mm			
Material CARBIDE			
Operations	Probe	Flute 1	Prf fin
Feed [mm/Min]	2000	100	15
Power [kW]		2	2
Cutting feed [m/s]		18	24
Used wheels		15	20
Grinding time [s]	238	374	1667
Total cycle time	37 Min 58		



The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

15	1V1 Ø125 D64
20	14EE1 Ø40 D25



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, STL647
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 4

responsible engineer: OP,27.4.09

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